

Work Order ID 63727-3

November 11, 2010 10:32:20 AM

SPLIT-3



Item ID: D3943-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Ground Handling Crank Assembly

Start Date: 11/11/10 Start Qty: 10.00

Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CL

Date: 10/11/11

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3943

C

0.00

100



Purchasing

Purchasing

Memo

Issue P/O: 12903

Purchase Part Number: 8143919

Supplier: Princess Auto

Certificate of conformity is required

Description: 4000 lbs lever chain hoist

0.00

CL 10/11/11 (15) 5

110



Packaging

Packaging

Receive & Inspect for Damage & MafI Certs

0.00

Memo

Ensure material certification is attached

0.00

CL 10/11/11 (15) 5

Work Order ID 63727

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Page 2

Item ID: D3943-041

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Setup Start



Revision ID:

Stop



Item Name: Ground Handling Crank Assembly

Start Date: 11/11/10 Start Qty: 10.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

8 10/11/22

(45)

Quality Control

130

0.00



Large Fab

Memo

0.00

EL 11-4-14 (X5)

Large Fab

1-Disassemble chain host as per dwg

2-Drill handle ass'y (D3943-051) as per dwg

Work Order ID 63727

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Item ID: D3943-041

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Setup Start



Revision ID:

Item Name: Ground Handling Crank Assembly

Stop



Start Date: 11/11/10 Start Qty: 10.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11/11/10 11/14/10 5

160

Hybrid safety Yellow 4.3.5.12

0.00



Powdercoat

Memo

0.00

Powder Coating

Memo

1- POWDER COAT:

Start Time: 8:30

Oven Temperature: 320

Finish Time: 9:00

1 BL 11-5-25.

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 11/05/12

Work Order ID 63727

November 11, 2010 10:32:20 AM



Page 4

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Setup Start



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Stop



Item Name: Ground Handling Crank Assembly

Start Date: 11/11/10 Start Qty: 10.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

EL 11-4-14



190



Large Fab

Large Fab

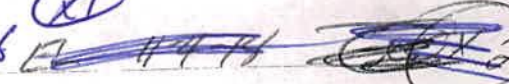
Memo

1-Assemble as per dwg
(assy landyard CBL-1240 to CBL-460)
2- touch up with paint if necessary

0.00

0.00

EL 11-5-14



200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

1-Calibrate and tag as per dwg

0.00

0.00

S 11/15/14



Work Order ID 63727

November 11, 2010 10:32:20 AM



Page 5

Item ID: D3943-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Ground Handling Crank Assembly

Start Date: 11/11/10 Start Qty: 10.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

PM 699/2

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/27

11/15/27

mf
11-05-27

Picklist Print

November 11, 2010 10:32:19 AM

Page 1

Work Order ID: 63727

Parent Item: D3943-041

Parent Item Name: Ground Handling Crank Assembly

Start Date: 11/11/10

Required Date: 11/17/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 09-06-02 EC Verified By: JLM IPP RevB:
add DEO DD 09.11.18 verified by:JLM IPP Rev:C as per dwg
REV.C DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
8143919 Lever Chain Hoist		Purchased	No			110	Each	0.0000	1	10			
D3943-051 Handle Assembly		Manufactured	No			180	Each	0.0000	1	10			
D3943-053 Chain Assembly		Manufactured	No			180	Each	0.0000	1	10			
D3943-3 Handle Extension		Manufactured	No			180	Each	2.0000	1	10			

CBL-1240 Cable	63739 x3	<u>Location</u> ST098	52978	<u>Loc Qty</u> 2 2	<u>Loc Code</u>	180	Each	329.0860	1	10			
-------------------	----------	--------------------------	-------	--------------------------	-----------------	-----	------	----------	---	----	--	--	--

<u>Location</u> ST275	<u>Loc Qty</u> 329.0860107 329.086011	<u>Loc Code</u>
--------------------------	---	-----------------

** D 3943-5 B 55711 x 1*
Not on parts list.

EL 11-5-23

CL 11/03/12

EL 11-4-18

EL 11-4-18

EL 11-4-13

EL 11-4-13

41

Picklist Print

November 11, 2010 10:32:19 AM

Page 2

Work Order ID: 63727

Parent Item: D3943-041

Parent Item Name: Ground Handling C-ank Assembly

Start Date: 11/11/10

Required Date: 11/17/10

Start Qty: 10.00

Required Qty: 10.00

CBL-460

Purchased No

180 Each

94.0000 2 20



Loop Sleeve



EL 11-4-13

Location

Loc Qty

Loc Code

ST284

66

114622

5

115579

61

ST285

28

113002

28

Manufactured No

180 Each

103.0000 1 10

D3585-1



Set Screw



EL 11-4-13

Location

Loc Qty

Loc Code

GA ST072

103

31571

3

55705

100

+1 @ 11-5-25

Manufactured No

180 Each

32.0000 1 10

D3949-041



Remove before Flight Flag Assembly



EL 11-4-13

Location

Loc Qty

Loc Code

ST487

32

48280

32

Manufactured No

180 Each

1.0000 1 10

D3954-7



Ratchet Lug



EL 10-11-31

Location

Loc Qty

Loc Code

ST102

1

55710

1

63738

4

4

November 11, 2010 10:32:19 AM

Shop Packet Print

Page 2

Picklist Print

November 11, 2010 10:32:19 AM

Work Order ID: 63727

Parent Item: D3943-041

Parent Item Name: Ground Handling Crank Assembly

Start Date: 11/11/10

Required Date: 11/17/10

Start Qty: 10.00

Required Qty: 10.00

AN5-11A Purchased No

180

Each

46.0000

1

10



Bolt



EL 11-4-13

Location

Loc Qty

Loc Code

ST

29

115374

29

ST338

17

115422

17

180

Each

86.0000

1

10

AN960-516

NAS1149F0563P Purchased

No



WASHER



EL 11-4-13

Location

Loc Qty

Loc Code

ST346

86

110098

86

180

Each

1,389.000

1

10

MS21042L5

Purchased

No



Nut



EL 11-4-13

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1363

115156

163

115594

500

116104

200

116105

500

EL 11-5-25

Picklist Print

Page 4

November 11, 2010 10:32:19 AM

Work Order ID: 63727

Parent Item: D3943-041

Parent Item Name: Ground Handling Crank Assembly

Start Date: 11/11/10

Required Date: 11/17/10

Start Qty: 10.00

Required Qty: 10.00

S1475

Purchased

No

180

Each

25.0000

1

10



inventory



EL 11-4-18

Location

Loc Qty

Loc Code

ST396

25

113079

11

113847

14

3408A59

Purchased

No

180

Each

23.0000

1

10



BALL PLUNGER



EL 11-4-18

Location

Loc Qty

Loc Code

ST401

23

111948

2

113854

21

HX-15

Purchased

No

180

Each

50.0000

1

10



1/4-20 UNCx3/4 S.H.C.S.



EL 11-4-18

Location

Loc Qty

Loc Code

ST390

50

114383

50

HX-16

Purchased

No

180

Each

100.0000

3

30



EL 11-4-18

Location

Loc Qty

Loc Code

ST390

100

113771

100

3036 ST 35
clevis

M117412 x 3

M 116125 x 2

EL 11-4-18

03943-5 B 55711 x 2 EL 11-4-18
(rework)

November 11, 2010 10:32:19 AM

Shop Packet Print

Page 4

ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN5-11A	BOLT	
32	1			AN960-516	WASHER	
33	1			MS21042L5	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
41	1			S-1475	SPRING	REID SUPPLY
42	1			3408A59	BALL PLUNGER	McMASTER CARR
43	1			HX-15	SOCKET HEAD CAP SCREW 1/2-20 UNC X 0.75 LG	HASKINS
44	1			HX-16	SOCKET HEAD CAP SCREW 1/2-20 UNC X 1.0 LG	HASKINS

CL 101111
W101.63727

RELEASED
2010-10-18
JWB

C	RMV FINISH -041 (ZN A8-2), ADD NEW FINISH -051/-053/-1/-3 (A8-3/-4/-5), ADD CALIBRATION (A8-2), (1) HX-16 WAS HX-15 (B3-1, C3-1), PAR 10-001	CP	10.01.26
B	SHT 1 PL, ITEM 31 WAS AN4-10A, ITEM 32 WAS AN960-416, ITEM 33 WAS MS21042-4, ITEM 43 WAS 0.75 LG. SHEETS 2 - 5 NOTES: FINISH FOR ALL COMPONENTS NOW YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP	DRAWING NO.	REV. C
CHECKED	JP	D3943	SHEET 1 OF 5
MFG. APPR.	JP	TITLE	SCALE
APPROVED	JP	GROSS WEIGHT TOW CRANK ASSY	NTS
DE APPR.	N/A	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS RELEASED ON THE EXPRESS CONDITION THAT THE USER TO BE USED FOR ANY PURPOSES IS TO BE COMPLIED WITH THE TERMS AND CONDITIONS OF THE DART AEROSPACE LTD. RELEASED FROM DART AEROSPACE LTD.	
DATE	10.01.26		

REMOVE AND RETAIN
RUBBER HAND GRIP

DISCARD PIN

RETAIN PIN

REMOVE &
DISCARD HOOK

8143919 LEVER CHAIN HOIST
(SHOWN PRIOR TO MODIFICATION)
(CHAIN SHOWN SHORTENED FOR CLARITY)

AN5-11A BOLT
AN960-516 WASHER
MS21042L5 NUT

3408A59
BALL PLUNGER

8143919
LEVER CHAIN HOIST

(CHAIN NOT SHOWN FOR CLARITY)

RE-INSTALL
RUBBER HAND-GRIP
HERE

D3943-3
HANDLE EXTENSION

D2690-4 LANYARD

D3949-041 FLAG

HX-16 S/H CAP SCREW

HX-15 S/H CAP SCREW
S-1475 SPRING

CALIBRATION TAG

D3585-1 SET SCREW

RE-INSTALL PIN

D3954-7 RATCHET LUG

D3943-053 CHAIN ASSY

(CHAIN SHOWN SHORTENED FOR CLARITY)

D3943-041 GROUND HANDLING CRANK ASSEMBLY

NOTES -041:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3943-041" USING FINE POINT PERMANENT INK MARKER
- 7) CALIBRATION TAG PER DART QSI 008 4.4 (ZN C1-2)

W10: 63727

DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP	DRAWING NO.	REV. C
CHECKED	JP	D3943	SHEET 2 OF 5
MFG. APPR.	JP	TITLE	SCALE
APPROVED	JP	GROSS WEIGHT TOW CRANK ASSY	NTS
DE APPR.	JP	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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RELEASED
2010-02-10

D3943-1 HANDLE

2 PL

9.75

2.00

Ø0.31
THRUØ0.12
THRUD3943-7 STUD
2 PLTHREAD $\frac{1}{4}$ -20 UNC-2B
2 PLTHREAD $\frac{1}{4}$ -20 UNC-2B
THRUVIEW A-A
A5.3
B5.3
(SCALE 2X)

D3943-5 PLATE

2 PL

9.37

D3943-051 HANDLE ASSEMBLY

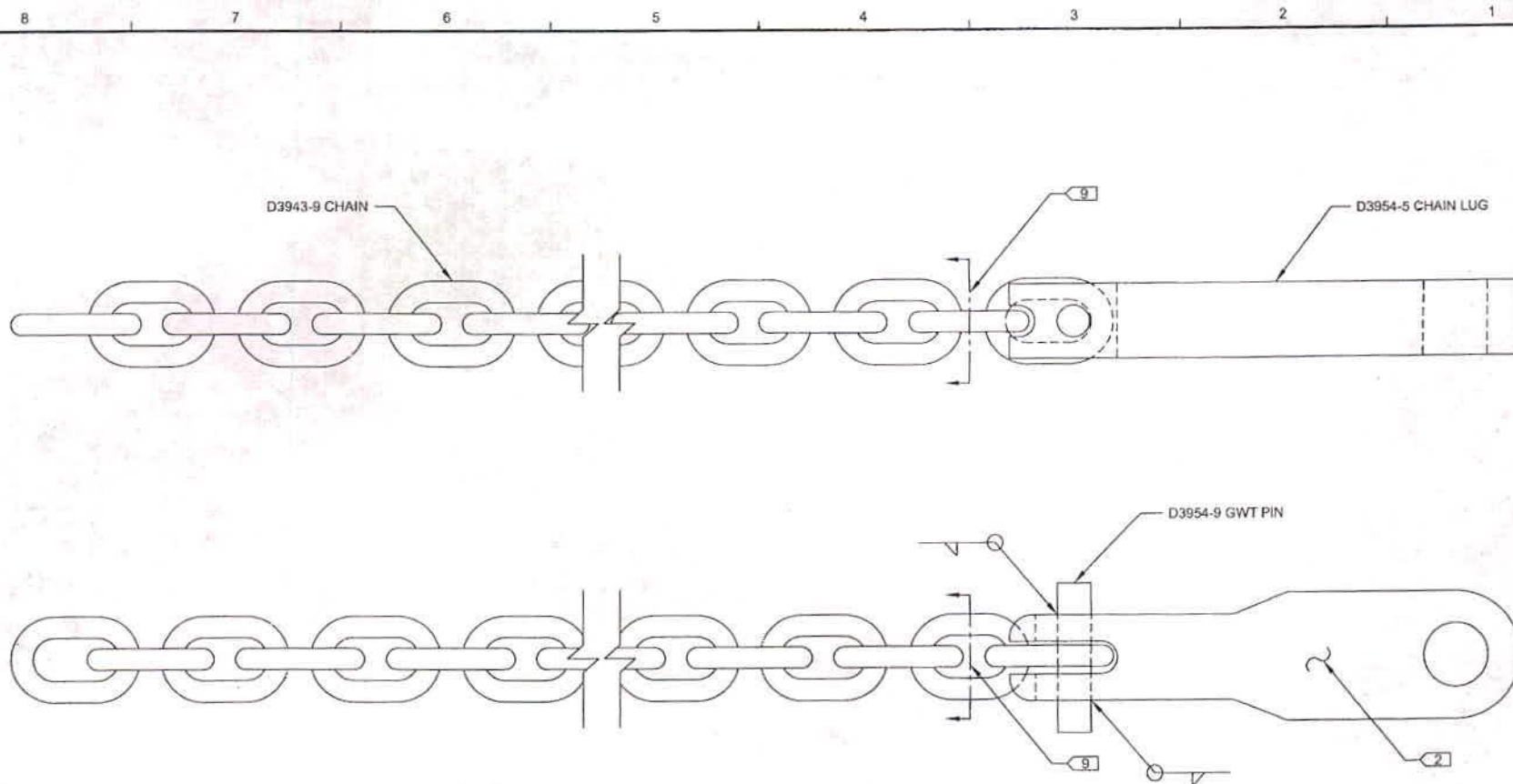
NOTES -051:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
- 3) TOLERANCES: X.XX DIMENSIONS \pm 0.06 ALL OTHERS
PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) MASK ALL THREADS PRIOR TO POWDER COATING

w10' 63727

RELEASED
2010-02-10
NH

DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	97	DRAWING NO.	REV. C
CHECKED		D3943	SHEET 3 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED	N/A	GROSS WEIGHT TOW CRANK ASSY	NTS
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DATE	10.01.26		



D3943-053 CHAIN ASSEMBLY

W10.63727

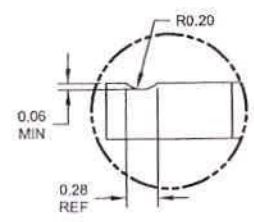
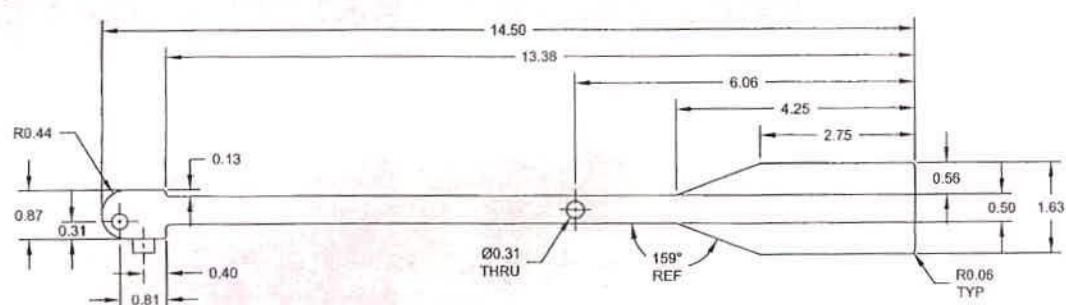
RELEASED
2010-02-10
WNP

NOTES -053:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER QSI 004
- 9) MASK CHAIN FROM THIS POINT ON PRIOR TO POWDER COATING

DESIGN	DSTOW/AJS	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D3943	SHEET 4 OF 5
APPROVED	WNP	TITLE	SCALE
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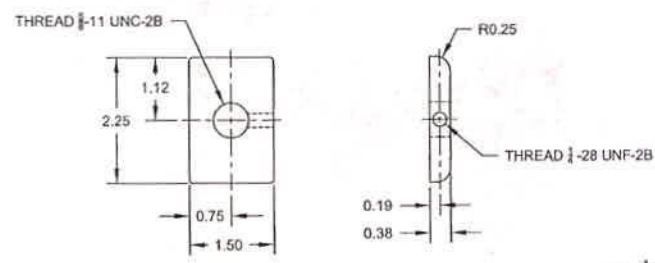
8 7 6 5 4 3 2 1



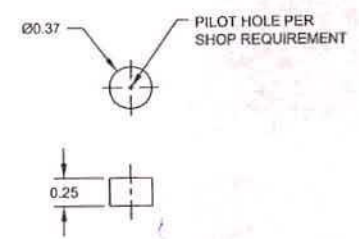
DETAIL B-B C7-5
(Dimple Detail)
(Scale 2X)



D3943-3 HANDLE EXTENSION



D3943-5 PLATE



D3943-7 STUD
(Scale 2X)

NOTES -11/-13:
1) MATERIAL -3 & -5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1006
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S

OR: MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

- △ 2) FINISH -3: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
-5 & -7: NONE
3) TOLERANCES: PER DART QSI #18 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE

w/10! 63727

RELEASED
2010-02-10

DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>qj</i>	DRAWING NO.	REV. C
CHECKED	<i>[Signature]</i>	D3943	SHEET 5 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	GROSS WEIGHT TOW CRANK ASSY	NTS
DE APPR.	<i>N/A</i>	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND NOT FOR CONSTRUCTION. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.01.26		

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

Purchase Order ID PO12903

Purchase Order Date 11/11/10
PO Print Date 11/11/10

Page Number 1 of 1

Order From :

VC PR1001

PRINCESS AUTO LTD.
P.O. BOX 1005
WINNIPEG, MB R3C 2W7
CA

~~REVISED~~
QTY

Contact Name
Vendor Phone 613 247 1651
Vendor Fax 613 247 1657
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

C/LC/4/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	8143919	Lever Chain Hoist	11/16/10 Yes	5.00 Each	Purolator ground	\$159.9900	\$799.95

Special Inst: AS PER DWG D3943 REV. C
B63727
PRINCESS AUTO P/N: 8143919

PO Total:

\$799.95



PO Instructions: PLEASE SHIP PUROLATOR ACCT: 7684382

Change Nbr: 2

Change Date: 11/11/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Princess Auto Ltd.

Ottawa
1111 Ages Drive
Ottawa, ON K1G6L3

Date 11/11/2010 Time 5:09 pm

~~Ref~~ ~~Session~~ ~~Posi~~ ~~Unit~~ ~~Store~~

8 11966 6615 1454862 16

Team Mbr Till 6096

SOLD TO: TEAM MEMBER:

073126 JIM A. 6615

DART AEROSPACE

PO #P012903

~~Ref~~ ~~Session~~ ~~Posi~~ ~~Unit~~ ~~Store~~

B 8143919 5 159.99 799.95

HOTST CHAIN 2 TON LEVER

G 9999998 1 6.00 6.00

HANDLING FEE

*Send To:

DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A1K7
(613) 632-5200

Subtotal 805.95
GST 5% 13568217 0.30
HST 13% R104304738 103.99
PST 0.0% 0.00
Total 910.24

A/R Account (910.24)
073126

Item Count: 5

CUSTOMER COPY

Electric, propane and kerosene heaters are
here to keep you working right through
winter



00016145486210321

8
10/11/22

INTERNAL CALIBRATION CERTIFICATE

Instrument #	Description	Serial #
D3943-041	Ground Handling Crank Assembly	B63727-3

Calibrated by	Date of calibration	Calibrated with	Due	Certificate #
ED	May 26th, 2011	ENG-07 25000lbs load cell		

New tool	Disposed	In Repair	On Hold	Being Calibrated
N/A	N/A	N/A	N/A	N/A

Employee	Department	Comments:
N/A	N/A	MUST BE CALIBRATED WITH IN 1 YEAR OF PURCHASE OR FIRST OPERATION

Spec.	Tolerance is + / -	Result	Pass Fail
3500LBS	3500-3700LBS	3640LBS	PASS

Entered By:
Eric Downing QC Coordinator